

Work Order ID 73013

Tuesday, August 23, 2011 3:33:13 PM



Page 1

Item ID: D3391-025

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 11-08-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3391

Rev H/ DEO

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599 Rev: ____ & Dwg D3391 Rev: ____

scribe batch # on fwd end at 90 degree

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

111

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

1 Ø
Anam.L 11/09/02

1 Ø
Anam.L 11/09/02

29 11.9.13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

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QC:

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

0.00

and 11/09/14

1 15

Memo

1-Machine as per Folio FA 599 Rev: *AA* & Dwg D3391 Rev: *H*
2-Deburr

130



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

and 11/09/14

1 0

Memo

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

SL 11-09-19

Memo

Dart Aerospace Ltd

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H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160 	BENDING MACHINE - SKIDTUBES	0.00							
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

DP

11-10-12

SAD 11-10-12 (1)

J. O. BEN/11/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop





QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open Aft cap pilot hole to .208" as per Dwg D3391								
	2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.								
	3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size*****								
	4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.								
	5-Open wearplate holes to 0.250" and c'bore as per dwg D3391								
	6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.								
	7-Deburr								



11-11-2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	5-11							

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

M 11-11-02 ①

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

SAD 11-11-02 -①

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP - 11-11-3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Dart Aerospace Ltd

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Revision ID:

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Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

8:50
320.0 F

9:20

1 x of M 11/11/09

250

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

1 x of M 11/11/09

260

HandFinishing

0.00



HandFinish

Hand Finishing

Memo

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

11119443
12/01

0.00

1 x of M 11/11/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 73013

Tuesday, August 23, 2011 3:33:13 PM



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Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sulu/10

Quality Control

280

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

SHIP

Packaging

290

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/14

ME 11-11-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

Tuesday, August 23, 2011 3:33:17 PM

Page 1

Work Order ID: 73013

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly



Start Date: 8/23/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM [] [] []
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6014-090 ALUMINUM EXTRUSION		Manufactured	No			100	Each	33.0000	1	1			

Location

Loc Qty

Loc Code

LG

33

56572

1

56179

32

D3670-4-200

Manufactured

No

230

Each

152.0000

4

4

SPACER

Location

Loc Qty

Loc Code

LG

56

70822

14

71850

42

LG001

96

72851

96

mm. 11/08/31

4 11-11-3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 23, 2011 3:33:17 PM

Work Order ID: 73013

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/23/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

96.0000

1

1



Aft Cap



xl

ululog

Location

Loc Qty

Loc Code

FP004

49

B73294

xl

68280

49

FP006

5

62678

5

FP-4

38

70945

1

71070

37

fp5

4

71038

4

D3537-1

Manufactured No

270

Each

17.0000

1

1



Wearpad



xl

ululog

Location

Loc Qty

Loc Code

FP001

10

69530

10

FP017

7

69817

5

70686

2

B74436

xl

D3537-7

Manufactured No

270

Each

0.0000

1

1



Wearpad



B71689 (xl) ululog

D3553-1

Manufactured No

270

Each

4.0000

1

1



Gasket



xl

ululog

Location

Loc Qty

Loc Code

FP013

4

56568

4

B73155

xl

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, August 23, 2011 3:33:18 PM

Work Order ID: 73013

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly



Start Date: 8/23/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3553-3 Manufactured No

270 Each

28.0000 1 1



Gasket



u u u u o g

Location

Loc Qty

Loc Code

FP

20

31631

20

FP013

8

53480

8

x1

D3672-1 Manufactured No

270 Each

1,186.000 2 2



u u u u o g

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

1184

64177

188

66821

496

72229

500

x2

ST077

2

52505

2

ALS4-1032-130 Purchased No

260 Each

1,559.000 14 14



Insert



u u u u o g

Location

Loc Qty

Loc Code

ST281

370

118386

370

ST282

1189

117717

54

118237

879

118312

256

x14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/23/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

270

Each

931.0000

12

12



Insert



u 11/09

Location

Loc Qty

Loc Code

ST282

931

M118696

x12

110768

62

117717

9

118386

860

AN3C4A

Purchased

No

270

Each

2,261.000

6

6



BOLT



u 11/09

Location

Loc Qty

Loc Code

ST350

2261

117313

2

117688

36

117795

1

117872

22

118012

20

118112

40

118451

1000

118628

1140

M118706

x6

Dart Aerospace Ltd

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Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 8/23/2011

Required Date: 9/9/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

270

Each

1,285.000

4

4



Bolt



ul

u/u/09

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1278

116419

28

116549

42

117343

474

117764

222

117872

12

118451

500

X4

AN960C10L

NAS1149C0332

Purchased

No

270

Each

0.0000

10

10



washer

M118354



(x10)

ul

u/u/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73013
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		tape	mm, L-02
3.500	+/-0.010	3.500	✓		vern	CNC-08
88.93	+/-0.030	88.93	✓		tape	mm, L-02
Ø3.200	+/-0.010	3.202	✓		mic	CNC-05
88.93	+/-0.030	88.93	✓		tape	mm, L-02
Ø3.750	+/-0.010	3.750	✓		vern	CNC-08
30° x 160° chamfer	+/-0.010	30x160	✓		11	

Measured by: MML	Date: 11/08/31
Audited by: RQ	Date: 11-9-13

HAAS Section						
1.526	+0.000/-0.030	1.503	✓		Vern RL-06	
7.500	+/-0.010	7.500	✓		Vern RL-02	
27.750	+/-0.010	27.750	✓		11-tape RL-04	
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
3.300	+/-0.010	3.300	✓		Vern RL-06	
0.200	+/-0.010	.200	✓		"	
3.520	+/-0.010	3.527	✓		"	
0.687	+0.010/-0.000	.687	✓		"	
R0.062	+/-0.010	R.062	✓		R-L	
Ø0.484	+0.005/-0.001	Ø.484	✓		Vern RL-06	

Measured by: MML	Date: 11/09/14
Audited by: J	Date: 11-04-19

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM *	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

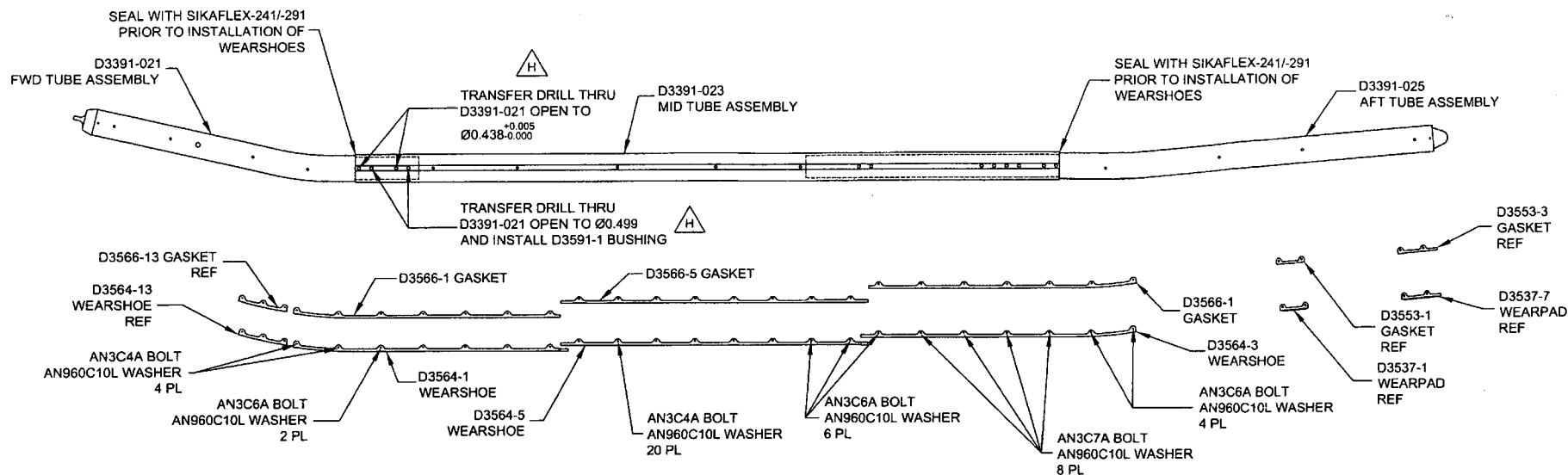
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

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73013



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
9	AN3C7A	BOLT
44	AN960C10L	WASHER

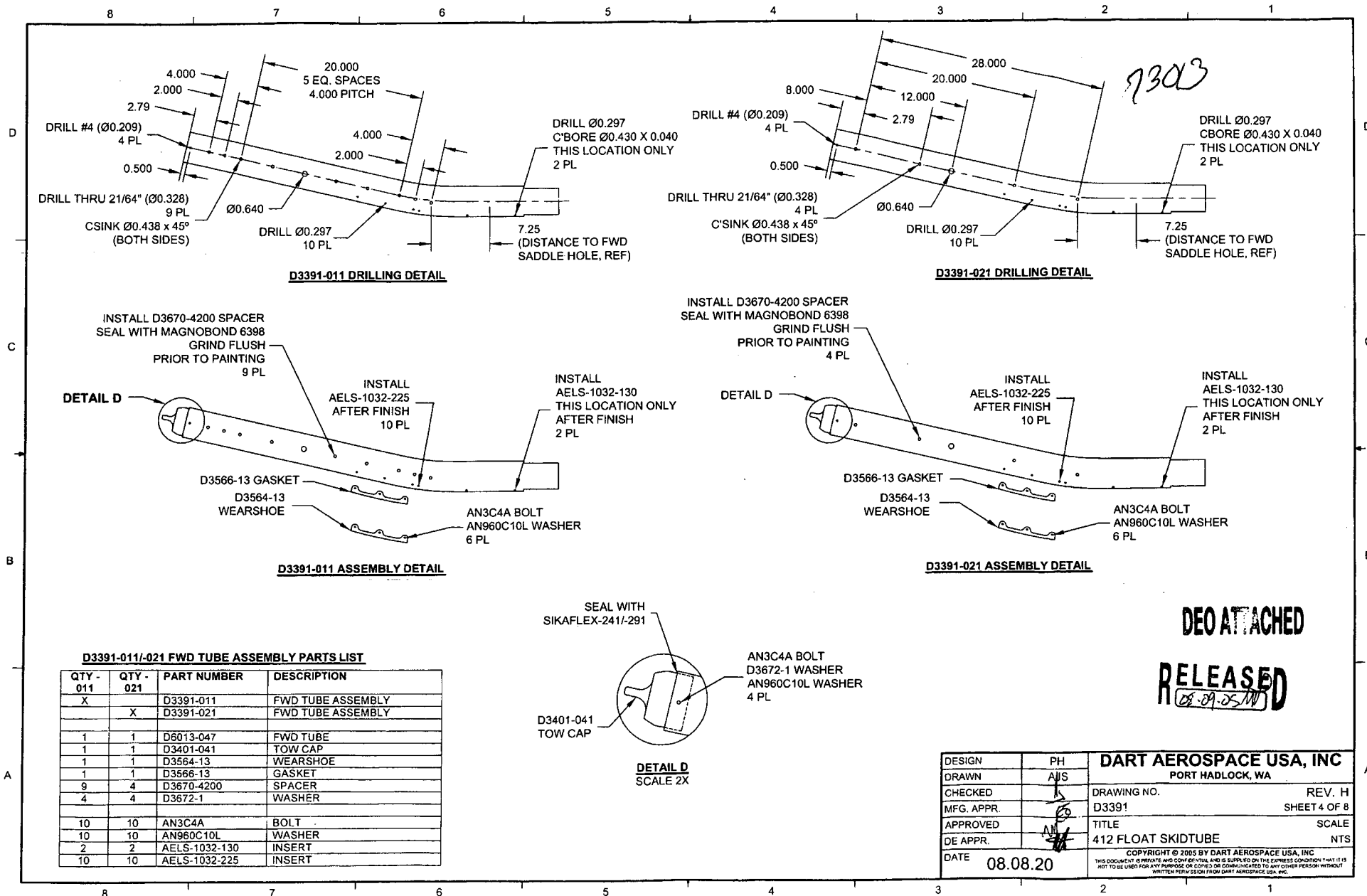
GENERAL NOTES

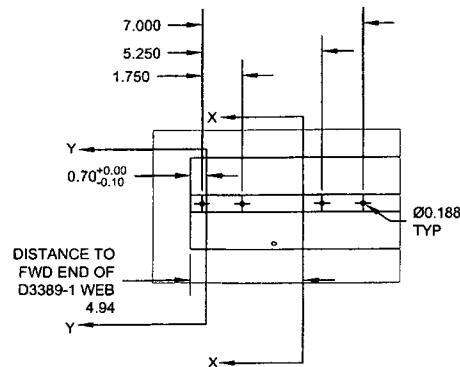
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DEO ATTACHED

RELEASED
08 09 25 11

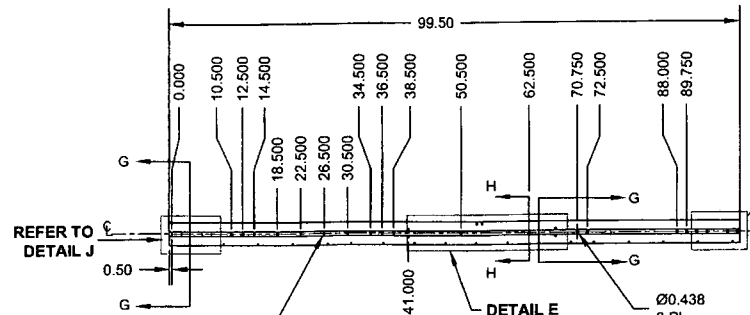
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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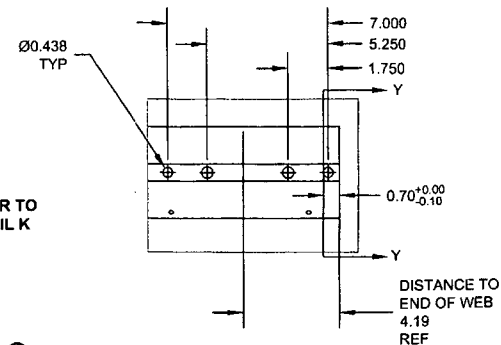
DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



D3391-013 ASSEMBLY DETAIL

REFER TO
DETAIL K

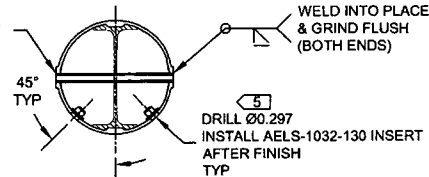


DETAIL K
SCALE 4X

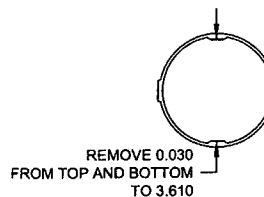


SECTION G-G
SCALE 5X

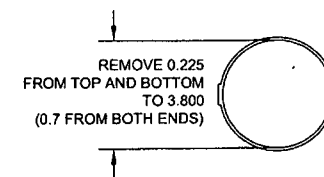
INSTALL
D3681-1 SPACER



SECTION H-H
SCALE 5X

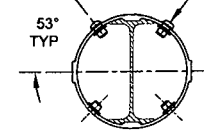


SECTION X-X
SCALE 5X

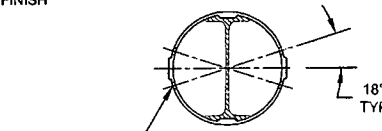


SECTION Y-Y
SCALE 5X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



SECTION M-M
SCALE 5X

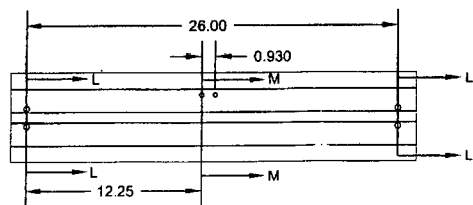


SECTION LL-LL
SCALE 5X

DRILL Ø0.250
4 PL

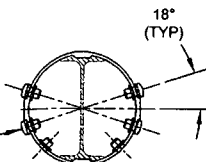
D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DETAIL E
SCALE NONE

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL



SECTION L-L
SCALE 5X

DEO ATTACHED

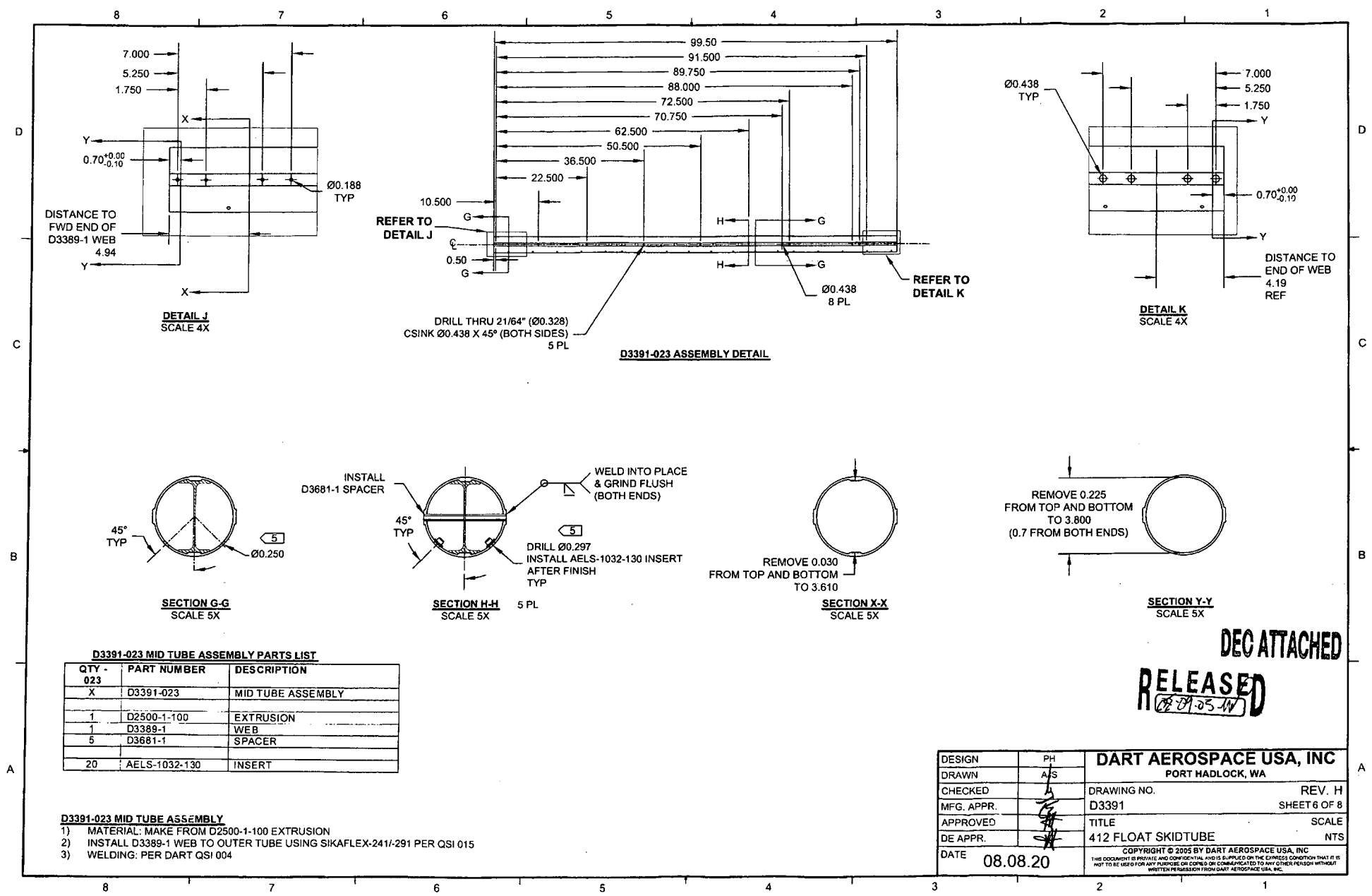
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DESIGN	PH	DART AEROSPACE USA, INC	
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MFG. APPR.		D3391	SHEET 5 OF 8
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D3391-013 MID TUBE ASSEMBLY

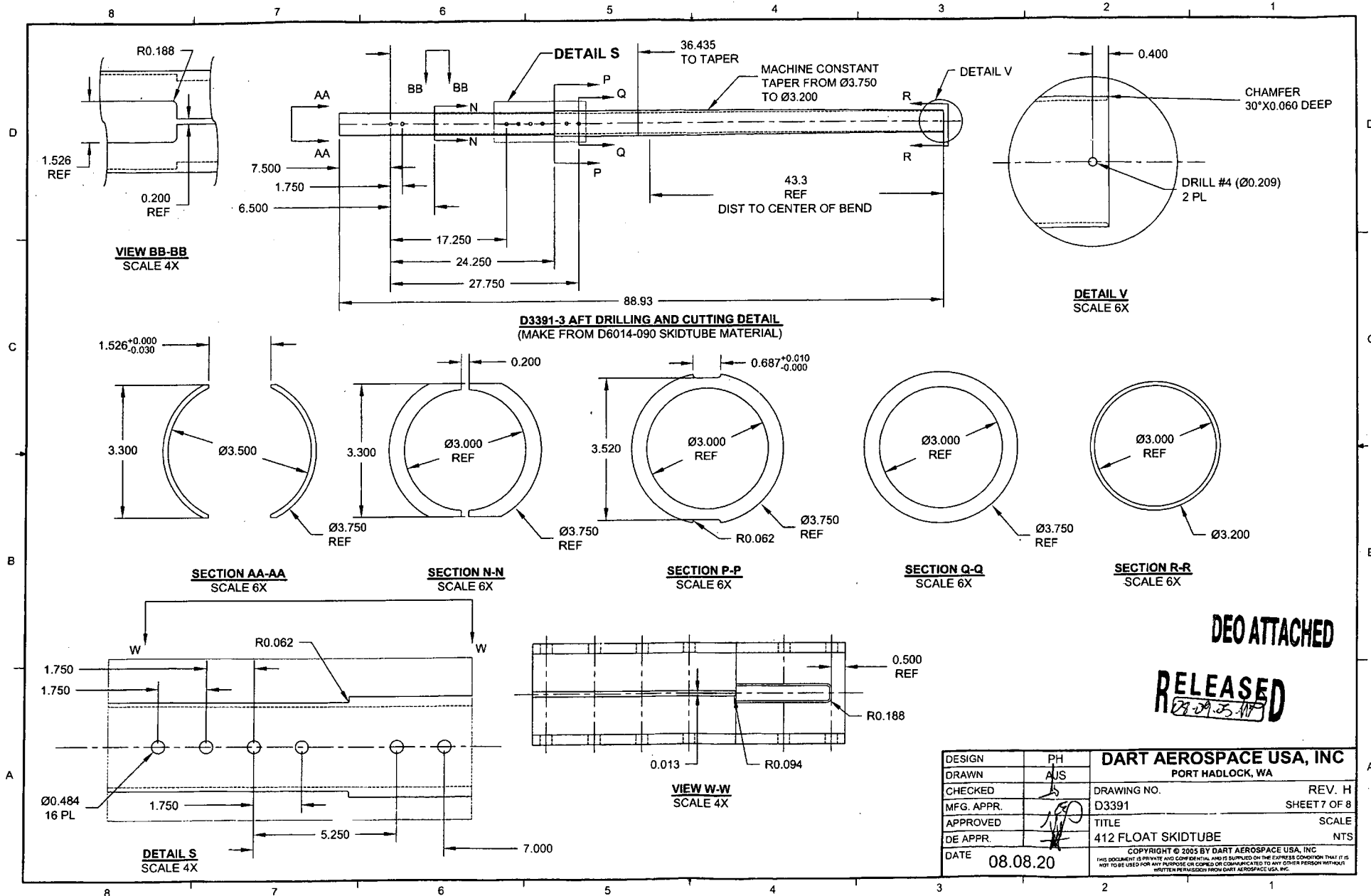
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

13813

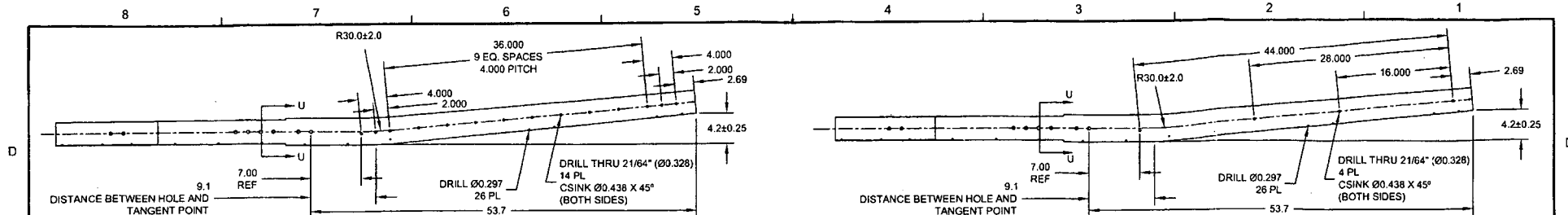


DEC ATTACHED
RELEASED
08-09-05-14

73013

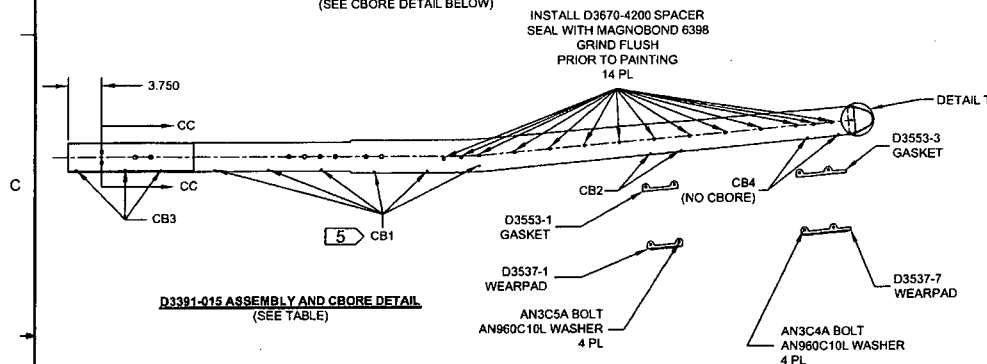


73013

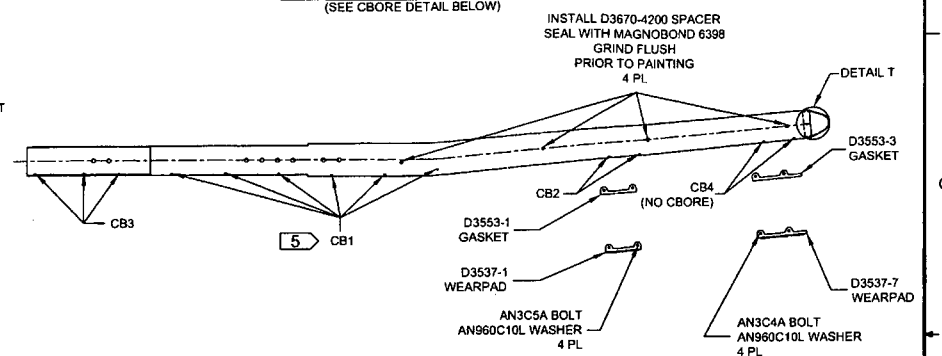


D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



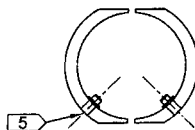
D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)



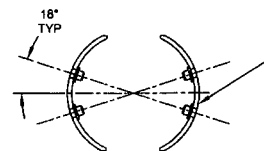
D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

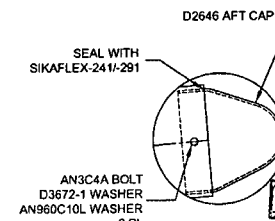


SECTION U-U
SCALE 3X



SECTION CC-CC
SCALE 3X

DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



DETAIL T
SCALE 4X

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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08-09-05/10

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

M303

RELEASED
2010-02-02

MP

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